Work Orde Monday, Decemb				*949	308*				AST	H	Page
Revision ID:	D3933-2 Aft Cabin Wal	II Protector, RH		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	12/24/2012 1/3/2013	Start Qty: 3.00 Req'd Qty: 3.00	*3* *3*		Cust Item I Customer:	D:					
Approvals:		n: MF	Date: \2-12-	Tooling:		ate:		R	tun Start Stop	! <i>N</i>	R1*
Sequence ID/ Work Center ID		Operation Description	Date:	SPC (Y/N):  Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Rン* Insp. Stamp
Draw Nbr	Rev	ision Nbr				<del></del>					
D3933	A										
*100 *100* Waterjet		Memo		0.00				3			B13 - 1- 1
FLOW CNC Waterje	t	I-Cut as pe Dwg Rev:_ Prog Rev:_ 2- Deburr is	4								
110		QC2- Inspect parts off n	nachine FAI/FAIB	0.00							
*11 <b>0</b> *		Memo		0.00				3			1313-

NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / U

DQA:	5	Date:	
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NCR: Y	es / No				WORK ORDER NON-O	CONF	ORN	MANCE / UPI	DATE	QA Closed:	Date	<u>:</u> :
Work Orde	r:				DISPOSITION	į			AGAINST D	EPARTMENT	/PROCESS	
Part N	0				Rework Scrap		1	Skid-tube Nachining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o				Use-as-is Work Order Update			oforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chief	f Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling				! !								
Operator Material												
Setup												
Other	$\dashv$							•				
Process	$\dashv$											
Supplier												
Training	_	İ										
Unapproved	-											
· · · · · · · · · · · · · · · · · · ·	<b>!</b>		•		F	AULT	CATE	SORY				
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	Bending				Bend	G	rain			Ovalized	[	Pressure/Forced
	Centre No	ot Conce	ntric to (	o/s	BOM/Route	Н	ardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	In	struct	ions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	∐M	lainte	nance		Part Moved		
	Heat Trea	at			Countersink	М	Iislabe	led	L	Positioned \		_
1	Inspectio		Tube		Cut Too Short	М	lisreac		Ĺ	Power Loss/	'Surge	Other
1	Ripples in				Drill Holes	<del></del>	ffset					
	Torque W			n  _	Drawing			Calibration				
	Turning S	equence			Finish	Ц٥	ut of S	equence				
	Wave/Tw	ist in Tul	oe .		Folio	1 0	utside	Dimensions	•			

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Work Orde Monday, Decem					*	949	റ	*							Page 2
Item ID: Revision ID: Item Name:	D3933-2 Aft Cabin Wa	Il Protector, RH			Accept		*\	1900	<b>040</b>	100	ገ*	Setup	Start Stop	I V	S1*
Start Date: Required Date: Reference:	12/24/2012	Start Qty: 3.00 Req'd Qty: 3.00	•	3* 3*				Cust Item I Customer:	D:					IN.	<b>5</b> /
Approvals:		nn:			Tooling	//NI).			ate:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II  120  *120  *120  *120  *120  *120  Quality Control  130  *120  Packaging  Packaging	)	Operation Description QC8- Inspect parts - second Memo  Identify as per dwg & Ste			0.00	Hours		Tool ID	Tool#	Plan Code	Accep Qty S	t Re Qt		Reject Number	Insp. Stamp
140 *140* QC Quality Control		QC21- Final Inspection -  Memo	Work Order Rele	ease	0.00							- <b>N</b>	15	13: (13	01-04 DH

												DQA:	Date	e:
NCR:	Yes	/ No					WORK ORDER NON-O	COI	VFORM	MANCE / UP	DATE			
						- 1			· · · ·			QA Closed:	Date	e: 
Vork Ord	er:						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Part	No.						Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR	No.						Work Order Update	]	ł.	Large Fab	Composite		Supplier	
Root					Des	cri	otion of work order update	П	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty			or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining														
napproved	ļ	<u> </u>	<u> </u>	<u> </u>				<u> </u>	T CATE	CORV				
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		Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved	_	
		Heat Trea	it				Countersink		Mislabe	led		Positioned \	Wrong _	
		Inspection	n Strip in	Tube			Cut Too Short		Misread	i		Power Loss/	/Surge	Other
		Ripples in	Bend			L	Drill Holes		Offset					
		Torque W	aves in E	xtrusior	1		Drawing		Out of 0	Calibration				
	Г	Turning S	equence				Finish		Out of 9	Sequence				

Outside Dimensions

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Wave/Twist in Tube

Folio

Monday, December 24, 2012 11:10:23 AM

Work Order ID:

94908

Parent Item:

D3933-2

Parent Item Name:

Aft Cabin Wall Protector, RH

Start Date: 12/24/2012

Required Date: 1/3/2013

Start Qty: 3.00

Required Qty: 3.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04 GE PLASTICS LEXAN SI	НЕЕТ	Purchased	No			100	sf	555.0613	7.01	21.03	B13-	1-3	
				<b>Location</b>		Loc Qty	Loc	: Code					
				MAT019		555.0613					12		
				121	803	555.0613			171	812		)	

Page 1

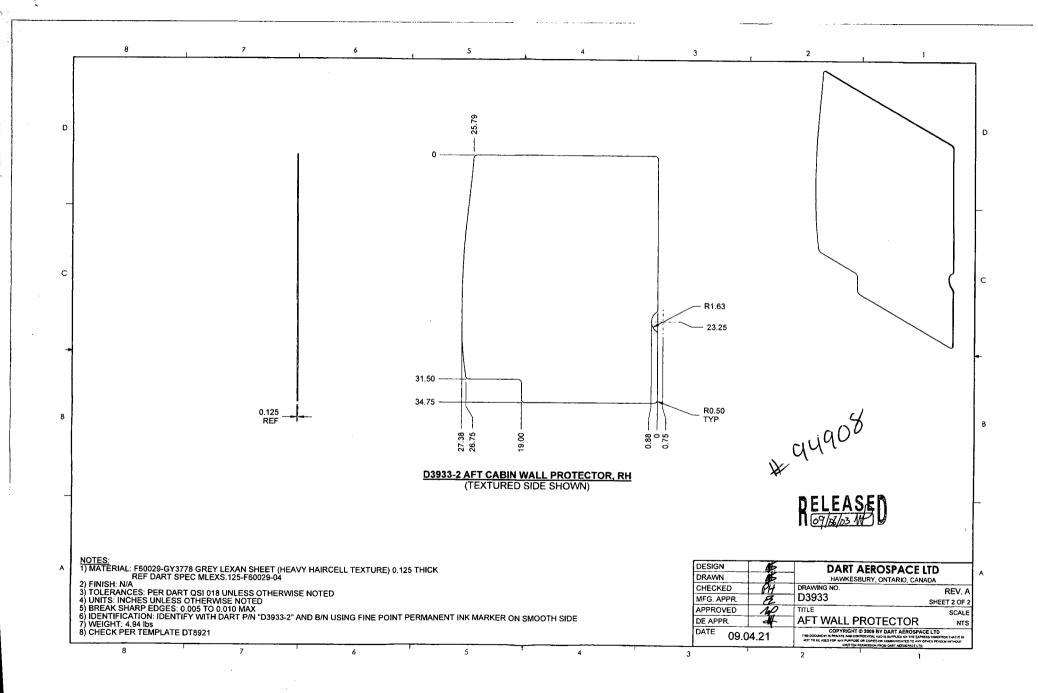
												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
Vork Ord	or:						DISPOSITION				AGAINST DE	• •		· · · · · · · · · · · · · · · · · · ·
vork Ora	er:						Rework	7		Skid-tube	Crosstube	7	Water Jet	Engineering
Part	No.						Scrap		1	Machining	Small Fab	4	d. Eng. Coor.	Quality
NCR	No.						Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite	Rec/Stoi	re/Packaging Supplier	Other
Root					Des	cri	otion of work order update	T	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		c	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data														
uip/Tooling														
perator														
laterial														
etup														
ther														
rocess														
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napproved		! 											·	
							F	AUI	T CATE	GORY	<del></del>			
Land	ng (	Gear			,		General		-		<u></u>	_	_	-
		Bending					Bend		Grain		<u> </u>	Ovalized		Pressure/Forced
	L	Centre No	ot Conce	ntric to (	D/S		BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks					Broken/Damaged		Inspect	on Incomplete	<u>_</u>	Part Incorre	ct	Weld
		Crushed/	Crimped.				Burrs	_	Instruct	ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	L	Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	at			L	Countersink	L	Mislabe	eled	_	Positioned \	_	-
	<u></u>	Inspectio	n Strip in	Tube	i	_	Cut Too Short		Misread	t	L	Power Loss/	/Surge	Other
	oxdot	Ripples in	Bend				Drill Holes	L	Offset					
		Torque W	/aves in E	Extrusion	า		Drawing		Out of	Calibration				
		Turning S	eauence			1	Finish		Out of 9	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio



			DQA:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

NCR:	NCR: Yes / No					WORK ORDER NON-C	ON	NFORI	MANCE / UP		QA Closed:	Date	
						DISPOSITION				AGAINST DEF			
Work Ord	er:						,				Altriviciti	_	_
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	۰. No.					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
						Use-as-is		Thern	noforming	Finishing			Other
NCR I	No. —				<del></del>	Work Order Update			Large Fab	Composite		Supplier	
Root					Descri	ption of work order update		nitial		tion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		-											
Operator	Ш	1									i		
Material	Ц	1											
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	<b></b>	uffs			ļ	Contamination	$\vdash$	Mainte		<b>├</b>	Part Moved		
	$oldsymbol{}$	eat Treat			<u> </u>	Countersink	$\vdash$	Mislabe			Positioned V		_
		spection	•	Tube	<u></u>	Cut Too Short	-	Misrea	đ	<u></u>	Power Loss/	Surge	Other
		ipples in I			L	Drill Holes	_	Offset					
	Te	orque Wa	aves in E	xtrusio	n	Drawing		Out of	Calibration				

Out of Sequence

Outside Dimensions

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

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DART AEROSPACE LTD	Work Order:	94908
Description: Aft Cabin Wall Protector, RH	Part Number:	D3933-2
Inspection Dwg: D3933 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/-0.030	, 88	_		T BUI	
19.00	+/-0.030	19,00			7	
26.75	+/-0.030	26.75	U		7	
27.38	+/-0.030	92.38	J		7	
34.75	+/-0.030	34,75	ı		7	. •
31.50	+/-0.030	31,50	U		7	
25.79	+/-0.030	26.79	)		7	,
0.125	+/-0.010	199	Ĺ		U BOZ	
23.25	+/-0.030	23.26	^		7	
			JAS			

			15		
Measured by:	B	Audited by:	€.89	Prototype Approval:	N/A
Date:	13-1-3	Date:	13 L3	Date:	N/A

Rev	Date	Change	Revise	ed b	V	Apple	oved
Α	09.06.22	New Issue	KJ	d()		1/1/	
				17	<del>)                                    </del>		